

Date: Wednesday, 2/1/2006 11:44:45 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 25708		
Estimate Number	: 11027		
P.O. Number	: N/A	Part Number	: D28021
This Issue	: 2/1/2006 S.O. No. : N/A	Drawing Number	: D2802 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: <u>SEE BELOW.</u>	Due Date	: 2/28/2006
Checked & Approved By	: <u>JL 06.02.01</u>	Qty:	8 Um: Each
Comment	: Est:B 02.03.18 Re-format NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
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Comment: Qty.: 1.5750 f(s)/Unit Total : 12.6000 f(s)
 6061-T6 Bar .50" x 6.0"
 Material: 6061-T6 bar 6.00" x 0.50"
 Batch: M 18463

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks 15.800" long

J.L 06.02.10 8

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per folio FA101
 Counter sink .375 dia as per dwg

J.L 06.02.10 8

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 06.02.10 8

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L 06/02/10 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/1/2006 11:44:46 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 25708

Part Number: D28021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble & Deburr NO sharp edges.

DL 06/02/13

(8)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-02-13

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

N/A

EC

PTO

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ~~WA~~ WA

WA-2 Lab 06-02-13 = 8

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

5.5 06/02/14

(8)

06/02/14

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06.02.13	8	parts to go to welding. No paint required (remove paint) permanent change	EC	06.02.13		EC	06.02.13

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

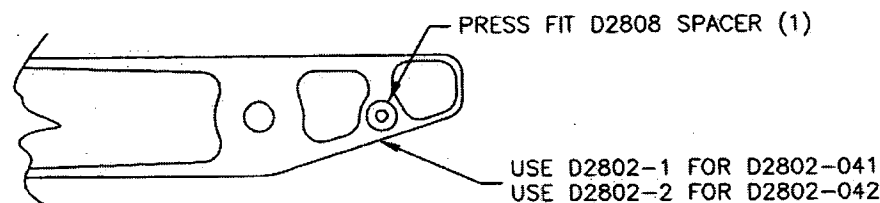
NOTE: Date & initial all entries

DART

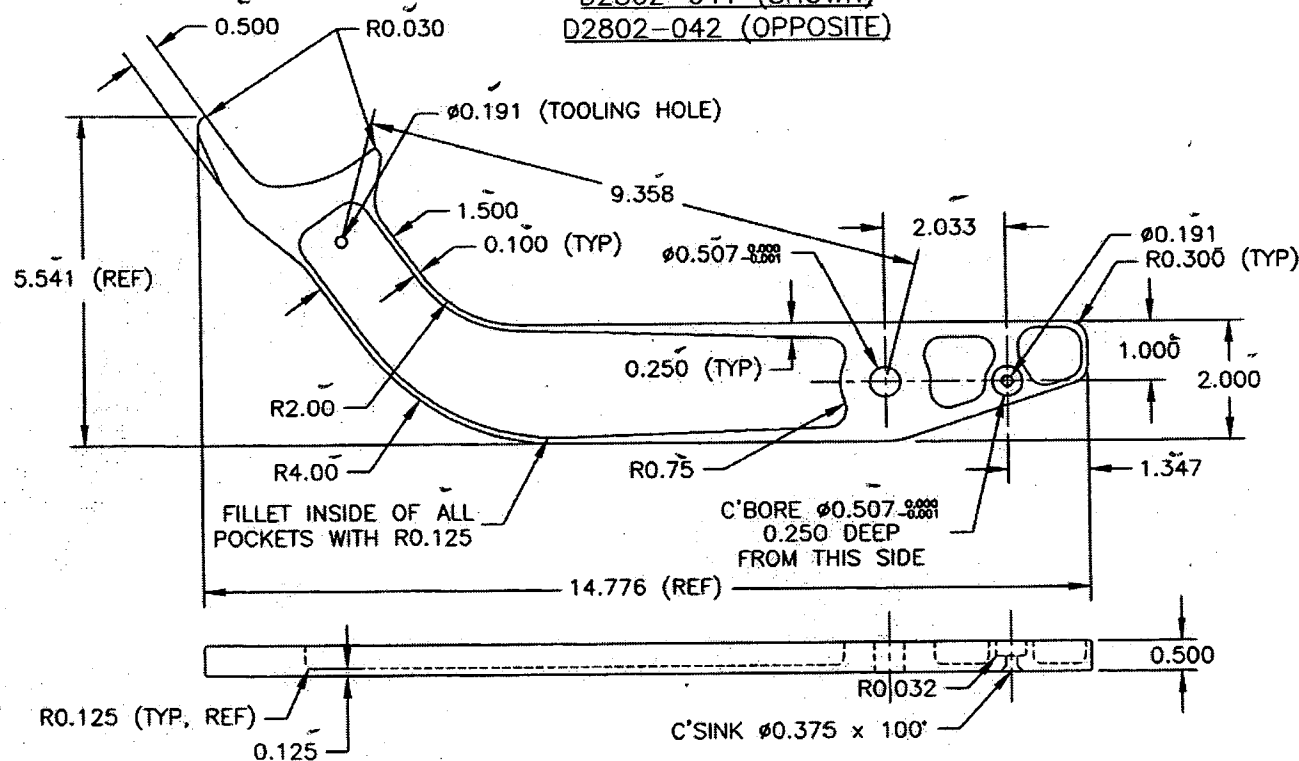


DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED <i>SC</i>	APPROVED <i>SC</i>	DRAWING NO. D2802	REV. A
DATE 00.11.03		TITLE ARM	SHEET 1 OF 1
A	00.11.03	NEW ISSUE	SCALE 1:3

RELEASED
00-11-13 *4*



D2802-041 (SHOWN)
D2802-042 (OPPOSITE)



D2802-1 (SHOWN)
D2802-2 (OPPOSITE)

SHOP COPY
RETURN TO
ENGINEER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25708

MACHINE PER DRAWING FILE "D2802-A1.DWG"
MATERIAL 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK (REF)
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART AEROSPACE LTD		Work Order: 25708
Description: ASM		Part Number: D28021
Inspection Dwg: D2802	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.500	$\pm .010$.501	✓			
.030	"	.030	✓			
Ø.191	$\pm .005$.192	✓			
1.500	$\pm .010$	1.500	✓			
.100	"	.101	✓			
9.358	"	9.358	✓			
Ø.507	$\pm .001$.507	✓			
.250	$\pm .010$.250	✓			
2.033	"	2.033	✓			
.300	"	.300	✓			
1.000	"	1.001	✓			
2.000	"	2.000	✓			
1.347	"	1.348	✓			
Ø.507x250		.507x24	✓			
.75	$\pm .030$.750	✓			
.125	$\pm .010$.125	✓			
4.0	$\pm .030$	4.0	✓			
2.0	"	2.0	✓			
5.541	$\pm .010$	5.543	✓			
1.125	"					
.125	$\pm .010$.132	✓			
.500	"	.499				
.032	"	.032	✓			

Measured by: J.L.	Audited by: <i>gml</i>	Prototype Approval: N/A
Date: 06.02.09	Date: 06/02/10	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	